X.

Punch and form D2332-11 to lenght as per dwg D2332 using DT8012

( need 2 per ass'y)

Brake NC

NCR:	Yes	1	No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA:Date:	_
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iten. i	C3 / NO				WORK ONDER HOR		MINIATUL 7		QA Closed:	Date	:			
Work Orde	er:				DISPOSITION		AGAINST DEPARTMENT/PROCESS							
					Rework	] [	Skid-tube	Crosstube	]	Water Jet	Engineering			
Part N	10.				Scrap Use-as-is	<b>┤                                    </b>	Machining	Small Fab Finishing		d. Eng. Coor.	Quality			
NCR No. Work Order Up						Ine	rmoforming Large Fab	re/Packaging Supplier	Other					
Root				Descri	ption of work order update	Initial		Action	Sign &	1				
Cause	Date	Step	Qty	(	or Non-conformance	Chief Er	ng De	escription	Date	Verification	QC Inspector			
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Equip/Tooling														
Operator						l <u>.</u>								
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Other								-	- ;	~				
Process			] ]						1	4				
Supplier			1			ļ			-					
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			•		F	AULT CA	<b>TEGORY</b>		, , , , , , , , , , , , , , , , , , ,					
Landi	ng Gear				General				_ * '	<u>.                                    </u>	_			
	Bending			L	Bend	- Grain	1 ·	` L	Ovalized	•	Pressure/Forced			
	Centre No	ot Concer	ntric to C	)/S	BOM/Route	Hard	ware		Over/Under	tolerance	Temperature/Cure			
	Cracks				Broken/Damaged	Inspe	ction Incomplete	<u> </u>	Part Incorred	ct .	Weld			
	Crushed/	Crimped			Burrs	Instru	uctions Incomple	te/Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled			
	Cuffs				Contamination	Mair	ntenance		Part Moved					
	Heat Trea	it			Countersink	Misla	beled		Positioned V	Vrong	_			
	Inspectio	n Strip in	Tube		Cut Too Short	Misre	ead		Power Loss/	Surge	Other			
	Ripples in	Bend			Drill Holes	Offse	t							
	Torque W	/aves in E	xtrusion		Drawing	Out	of Calibration		1					
	Turning S	equence			Finish	Out	of Sequence							
	Wave/Twist in Tube Folio					Outs	de Dimensions							

0.00

S.S Rod batch:

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)

\*\*\*\*\*\*ensure nothing is inside of tube before welding\*\*\*\*\*\*\*

Large Fab

Large Fab

									DQA:	Date:	
NCR: Ye	s / No				WORK ORDER NON-	CON	FORM	MANCE / UPDATE	T		
<del></del>	···								QA Closed:	Date:	
Work Order	:				DISPOSITION			AGAINST	DEPARTMENT	/PROCESS	•
Part No	)				Rework Scrap Use-as-is Work Order Update	f Therm	Skid-tube Crosstube Machining Small Fab noforming Finishing Large Fab Composite	Prod. Eng. Coor. Quality ing Rec/Store/Packaging Other			
Root		,		Descr	iption of work order update	Ir	nitial	Action	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Description	Date	Verification	QC Inspector
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Landing	Gear				General	AUL.	CATE	<u> </u>			
	Bending Centre No	ot Concer	ntric to		Bend BOM/Route	$\vdash$	Grain Hardwa	ro	Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure
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-	Crushed/0	Crimped		<u> </u>	Burrs	-	•	ions Incomplete/Unclear	Part Lost/Mi	<del></del>	Wrong Stock Pulled
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م بخر ۲۰	Inspection		Tube		Cut Too Short	$\vdash$	Misread		Power Loss/		Other
€ [	Ripples in	-		,	Drill Holes		Offset			-	
- to	Torque W	aves in E	xtrusio	n	Drawing		Out of C	Calibration	r		
	Turning So				Finish		Out of S	Sequence			

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Folio

Work Ord March-12-13 1		377		*983				Page 3			
Item ID: Revision ID:	D2332-041			Accept	*N900	<b>040</b>	100	)*	Setup Start	ı vı	S1*
Item Name:	Lid Prop Asser	mbly 6.69" long			•				Stop	*N:	S2*
Start Date: Required Date:	3/11/13 : 3/22/13	Start Qty: 10.00 Req'd Qty: 10.00	*10* *10*		Cust Item I Customer:	D:					
Reference:			·	· .		·		I	Run Start	<b>+ 1</b>	D4+
Approvals:		in:	Date:			ate: ate:		-	Stop	17	R1° R2*
Sequence ID/ Work Center I	D	Operation Description QC9- Inspect visual per Q	SI004- Fusion Welds	Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*150* QC Quality Control		Memo		0.00	0613.5-9	24	)	/O <sub>X</sub>			·
<sup>160</sup> *160*		QC5- Inspect part comple	teness to step on W/O	0.00	3.5.9	OAS)		10 <sub>V</sub>			
QC Quality Control		Memo		0.00		5-83 y		<u> </u>			

170

\*170\* Small Fab

Small Fab

Memo

1- Tumble

2- Assemble as per dwg D2332

0.00

10 76,13.59 10 FF 13-05-10

NCR:	Vec	1	Nο

NCR: Y	es	/ No				WORK ORDER NON-C	CONI	FORN	AANCE / UPI	DATE	·		
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Work Orde	r.					DISPOSITION		<u></u>		AGAINST D	EPARTMENT,	/PROCESS	
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		Torque W		xtrusio	ո  _	Drawing	$\mathbf{H}$		Calibration				
		Turning S	equence		·	Finish	$\vdash$		equence				
		Wave/Tw	ist in Tub	oe .	ŀ	Folio		Outside	Dimensions				!

DQA:

Date:

Wave/Twist in Tube

Work Order ID 98377 \*98377\* Page 4 March-12-13 1:49:02 PM D2332-041 \*N900040100\* Item ID: Accept Setup Start **Revision ID:** Item Name: Lid Prop Assembly 6.69" long \*10\* **Start Oty: 10.00 Start Date:** 3/11/13 **Cust Item ID:** Required Date: 3/22/13 Req'd Qty: 10.00 **Customer:** Reference: Run Start Date:\_\_\_\_\_ Approvals: Process Plan: Tooling: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Operation Tool # Plan Set Up/ Tool ID Reject Reject Accept Insp. Work Center ID Description **Run Hours** Code Qty **Qty** Number Stamp 180 QC5- Inspect part completeness to step on W/O \*180\* QC 0.00 Memo Quality Control Identify as per dwg & Stock Location 5000 190 \*100\* Packaging 0.00 Memo Packaging

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

200

QC

Quality Control

MIJ 13-05-13

		,	
NCR:	Yes	/	No

DQA:

Date:

NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE															
										·		QA Closed:	Date	:	
Work Orde	r:						DISPOSITION			AGAINST	DEF	PARTMENT	/PROCESS		
Part N							Rework Scrap		ı	Skid-tube Crosstube Water Jet E  Machining Small Fab Prod. Eng. Coor.  Thermoforming Finishing Rec/Store/Packaging					
NCR N	o						Work Order Update			noforming Finishing Large Fab Composite	-	, ,	Supplier	Other	
Root					Des	crip	tion of work order update	l	nitial	Action		Sign &			
Cause		Date	Step	Qty		C	r Non-conformance	Ch	ief Eng	Description		Date	Verification	QC Inspector	
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	٦v	Nave/Tw	ist in Tub	oe .			Folio		Outside	Dimensions					

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Work Order ID:

98377

Parent Item:

D2332-041

Parent Item Name:

Lid Prop Assembly 6.69" long

**Start Date:** 3/11/13

Required Date: 3/22/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP: B02.08.12Re-format; Incorporated D2332-13/-11/-7/-5KJ/RF

Comments.	IPP Rev:C 08-06-										<del>-</del>		
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4-4A Bolt		Purchased	No			170	Each	99.0000	1	10	FF	13-0	5-10
			4.	Location		Loc Qty	<u>L</u>	oc Code					
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				123	900	73			<i>A</i>				
AN960JD416L Washer	NAS1149D0416J	Purchased	No			170	Each	6.0000	3	30	FF	13	-05-7
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304 SS Round bar .250									• - 8: side collin (182 d			4-3	-cS-
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M304TR0.500W.035		Purchased	No			110	f.	387.3199	1.25	13.15789	5 E8	< 13-	05-07
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	•						Rework	1		Skid-tube	7	i	Water Je	t∏	Engineering	
Part	No.						Scrap			Machining	Small Fab		Pro	d. Eng. Coor	$\square$	Quality
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Outside Dimensions

Wave/Twist in Tube

Folio

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Page 2

March-12-13 1:49:02 PM

Work Order ID: 98377 Parent Item: D2332-041 **Start Date: 3/11/13** Required Date: 3/22/13 **Start Qty: 10.00** Required Qty: 10.00 Parent Item Name: Lid Prop Assembly 6.69" long M304TR1.000W.049 No 100 23.9616 0.43 Purchased 4.526316 FF 13.05-07 304 RD Tube 1.00 x .049W Location Loc Qty Loc Code 4.5263 MAT018 125250 23.96163 0.00003 117598 120654 23.9616 MS21042L4 170 10 No Each 4,222.0000 Purchased FF 13-05-10 Nut Loc Qty Loc Code Location 318 FP001 \* 306 122452 8182 12 FP-001 12 8182 12 GA 40 تنم و بخر 121444 40 ST314 84 116548 12 119017 20 123248 36 123355 16 ST506 768

768

3000

123900

124231

ST518

NCR: Ye	s / No				WORK ORDER NON-C	ONF	ORN	MANCE / UPD	DATE	QA Clos	sed:	Date:	
Work Order	:				DISPOSITION				AGAINST DE		ENT/PROCESS		
Part No					Rework Scrap Use-as-is Work Order Update			Skid-tube Crosstube Machining Small Fab Finishing			Water J Prod. Eng. Cod Store/Packagii Suppli	or.	Engineering Quality Other
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Cause	Date	Step	Qty		or Non-conformance	Chief	f Eng	Descri	ption	Date	. Verificat	tion	QC Inspector
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DQA:

Date:

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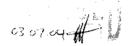




À	DESIG	#	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
	CHEC	(ED)	APPROVED	DRAWING NO. REV. C
"		#	#	D2332 SHEET 1 OF 2
	DATE			TITLE SCALE
	03.0	7.03		LOD PROP ASSEMBLY NTS
	Α		94.12.16	NEW ISSUE
	В		97.09,30	CHANGE 416 WASHERS TO 416L
	С		03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)

ADD -045

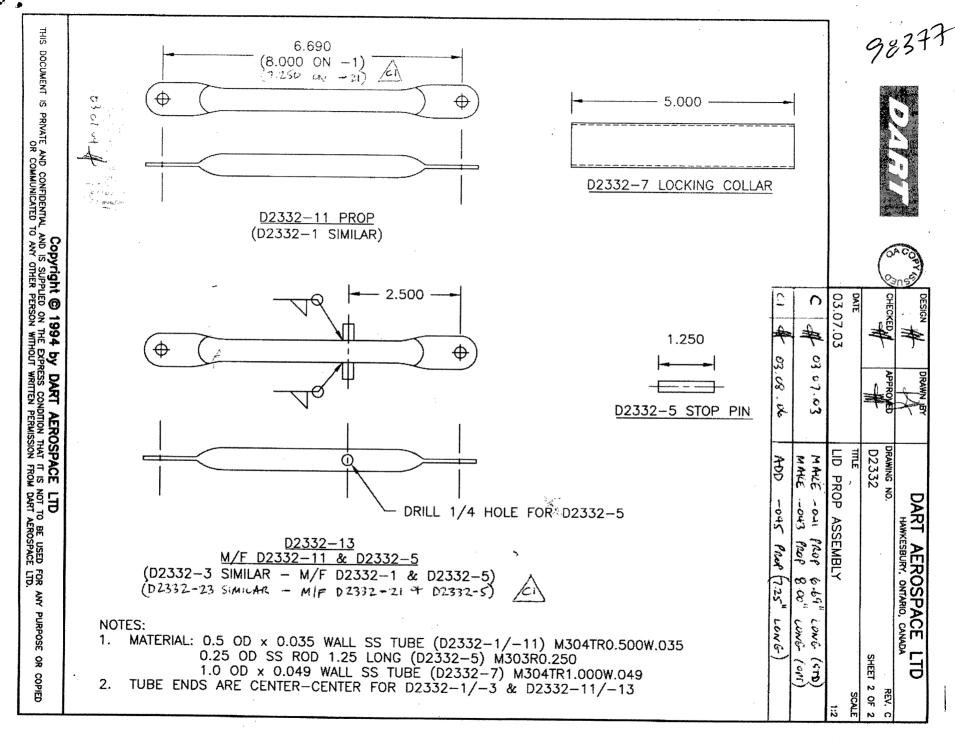
PROP (7.25" LONG



D2332-11 (USE D2332-1 ON -043) (USE 02332-21 ON -045) (CI D2332-13 (USE D2332-3 ON -043) (USE D2332-23 ON -045) D2332-7 AN4-4A BOLT (1) AN960JD416L WASHERS (3) MS21042L4 NUT (1) D2332-041 SHOWN (D2332-043 SIMILAR) (02332-045 SIMILAR)

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